

Work Order ID 104934

104934

Page 1

July-23-13 12:57:09 PM

Item ID: D4406-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 7/23/13 Start Qty: 4.00

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MJS

Date: 13-07-25 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4406-3

prog rev: C

dwg rev: C

2-Deburr if required

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

8 4

0

13.12.19

8 4

0

13.12.19

Work Order ID 104934

104934

Page 2

Item ID: D4406-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 7/23/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-89

0.00

8/12/13

8

120

QC

Memo

Quality Control

130

0.00

DAS

30

9-89

0.00

8

130

Small Fab

Memo

Small Fab

Form as per dwg D4406

8/12/13

140

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

0.00

8/12/13

8

140

QC

Memo

Quality Control

Work Order ID 104934***104934***

Page 3

July-23-13 12:57:09 PM

Item ID: D4406-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Wearplate Assembly

Start Date: 7/23/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

0.00

150

Large Fab

Memo

0.00

Large Fab

Weld bar as per dwg

A/R 2059b hardcoat Batch#: _____

Weld bar to wearplate as per dwg

A/R s.s. rod Batch #: _____

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

6.00

Quality Control

165

QC5- Inspect part completeness to step on W/O

0.00

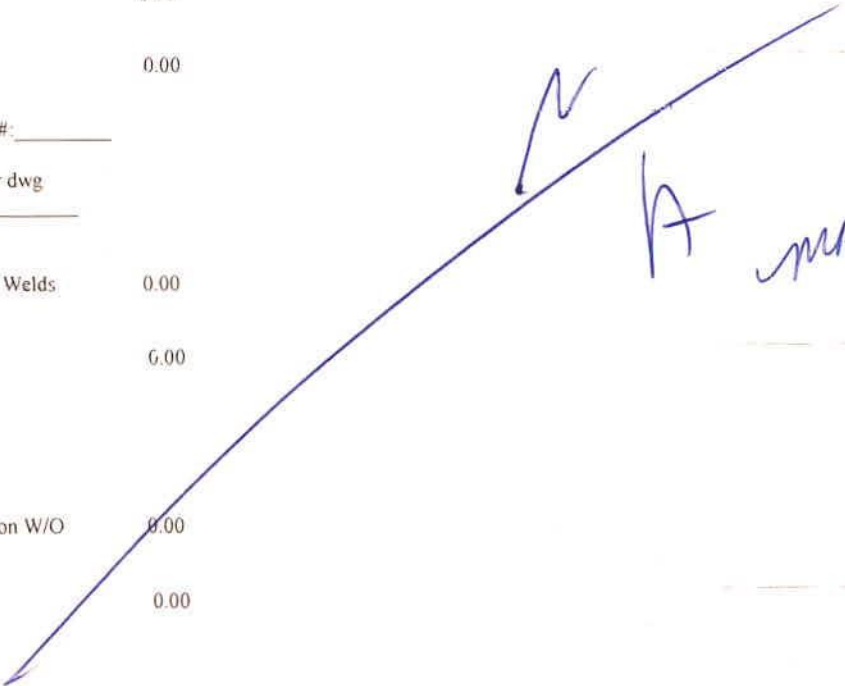
165

QC

Memo

0.00

Quality Control



A 14-8-21

Work Order ID 104934

104934

Page 4

July-23-13 12:57:09 PM

Item ID: D4406-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 7/23/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

170

Small Fab

Memo

0.00

Small Fab

Apply coating as per dwg D4406

180

180

QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

190

190

Packaging

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

N
A
mtk 4-8-21

Work Order ID 104934

104934

Page 5

July-23-13 12:57:09 PM

Item ID: D4406-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 7/23/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

~~MC 14-08-21~~

MF
14-8-21

Picklist Print

July-23-13 12:57:09 PM

Page 1

Work Order ID: 104934
Parent Item: D4406-043
Parent Item Name: Aft Wearplate Assembly

Start Date: 7/23/13
Start Qty: 4.00

Required Date: 7/23/13
Required Qty: 4.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD IPP rev B 12.02.06 as per dwg
revPB1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3 Bar		Manufactured	No			150	Each	22.0000	2	8			

B104527 x 4

~~B10403~~

B103300 x 8

Location	Loc Qty	Loc Code
WA	12	
103500	12	
WA001	10	
103300	10	

M304S18GA
304/316 .050 Sheet

Purchased No

100 sf 394.0644 2.92 ~~12.294737~~

Ac 13.12.19

Location	Loc Qty	Loc Code
MAT019	80.11	
117188	5	
117766	5	
120604	5	
122325	3	
123155	3	
124572	59.11	
MAT020	313.95442	
120243	2	
121626	1.529894	
124029	86.096526	
M126098	224.328	

m126647 → 24.00

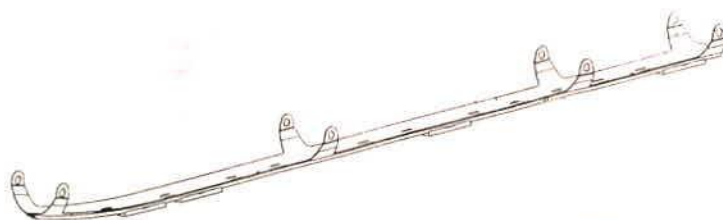
DART AEROSPACE LTD		Work Order:	104934
Description: Plate		Part Number:	D4406-3
Inspection Dwg: D4406 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

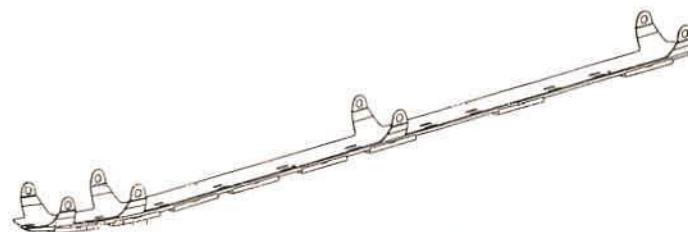
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.561	+/-0.010	.561	-		V	JKm-05
0.30	+/-0.030	.30	-		V	
0.88	+/-0.030	.88	-		V	
0.13	+/-0.030	.13	-		V	
0.31	+/-0.030	.31	-		V	
24.995	+/-0.010	24.995	-		T	JKm-06
47.958	+/-0.010	27.958	-		T	
54.178	+/-0.010	54.178	-		T	
2.43	+/-0.030	2.43	-		V	
7.77	+/-0.030	7.77	-		T	
7.203	+/-0.010	7.203	-		T	
3.63	+/-0.030	3.63	-		V	
4.00	+/-0.030	4.00	-		T	
7.071	+/-0.010	7.071	-		T	
7.800	+/-0.010	7.800	-		T	
0.050	+/-0.010	.045	-		V	

Measured by: <i>Ac</i>	Audited by: <i>DAS</i> 27	Preliminary Approval:
Date: 13.12.19	Date: 13/12/19	Date:

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-043	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	
C	13.05.08	Dwg Rev updated	KJ	



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

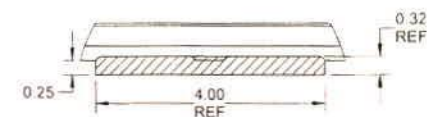
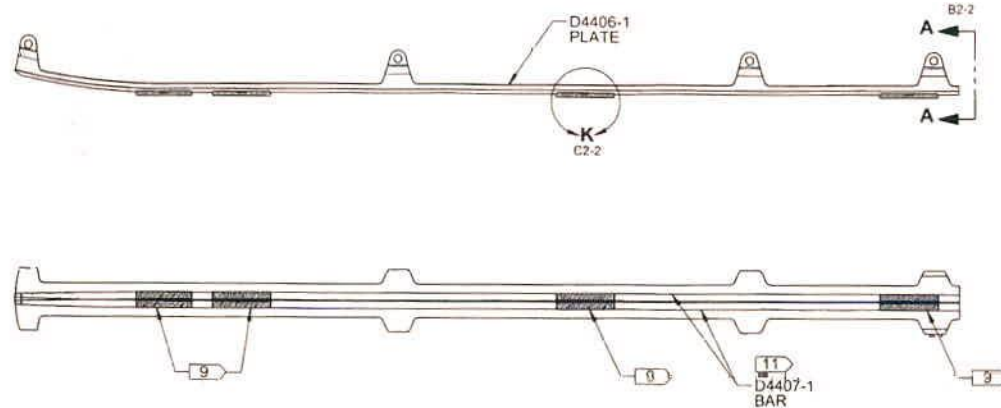
X				D4406-041 WEARPLATE ASSY	
X				D4406-043 WEARPLATE ASSY	
3	1		D4406-1	PLATE	
4	1		D4406-1	PLATE	
5	2		D4407-1	BAR	
6	2		D4407-3	BAR	
7	A/R	A/R	2059B	HARDCOAT	
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)	

104934 MJS
130725

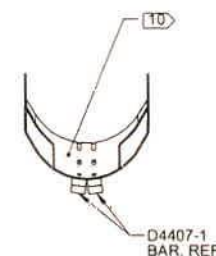
RELEASED
2013-03-21

C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED. SHT 5 FWD SLOT SIZES WERE 0.88 (REF NGR17-20311)		AJS	13.03.11
B	REVISE BILL OF MATERIAL. ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3. MODIFY DETAIL E & F (ZN B5-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)		RF	12.02.16
A	NEW ISSUE		RF	11.08.15
REV	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	UP	DRAWING NO.	REV. C	
MFG. APPR.	INT	D4406	SHEET 1 OF 6	
APPROVED	INT	TITLE	SCALE	
DE APPR.	INT	WEARPLATE ASSY	NTS	
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104934



DETAIL K C2-2
WELD BUILDUP DETAIL 4 PL
SCALE 4X



SECTION A-A C3-2
SCALE 2X

D4406-041 FWD WEARPLATE ASSY

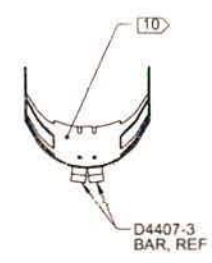
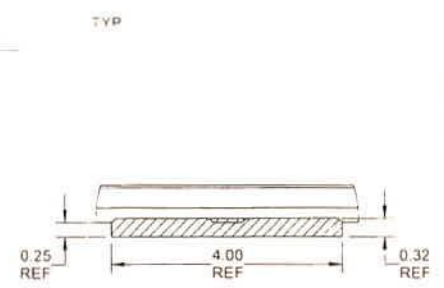
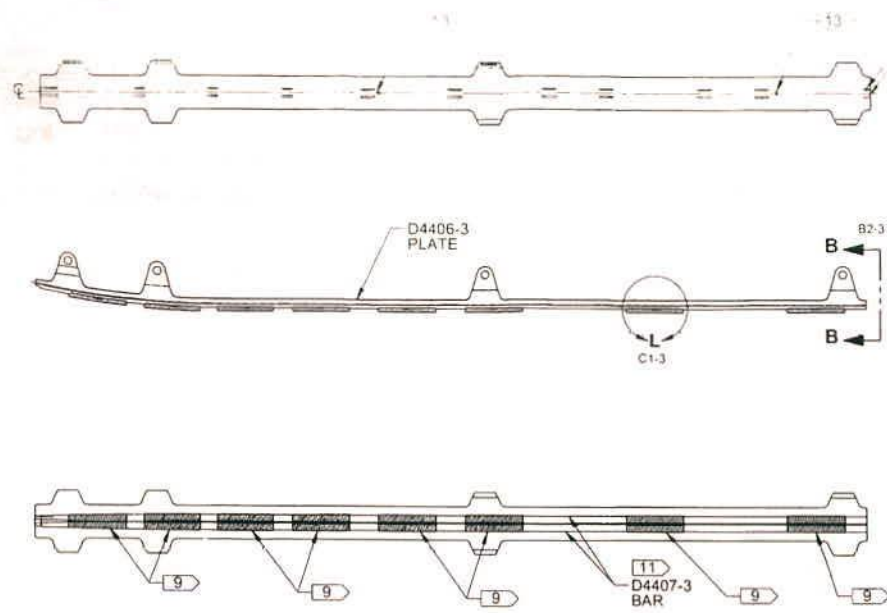
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

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CHECKED	97	DRAWING NO	REV. C
MFG. APPR.	13	D4406	SHEET 2 OF 6
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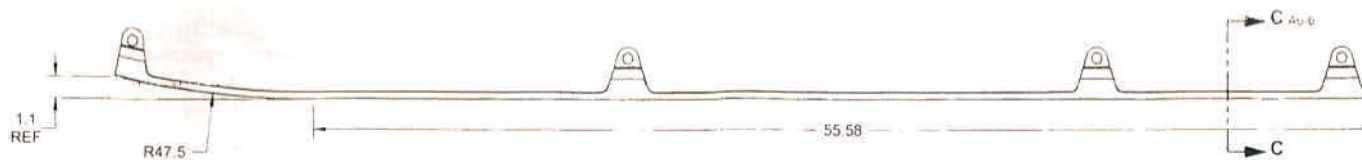
D4406-043 AFT WEARPLATE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 8.85 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
 - 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
 - 13) TRANSFER: Ø0.188 HOLES FROM D4406-3 TO D4407-3
 - 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

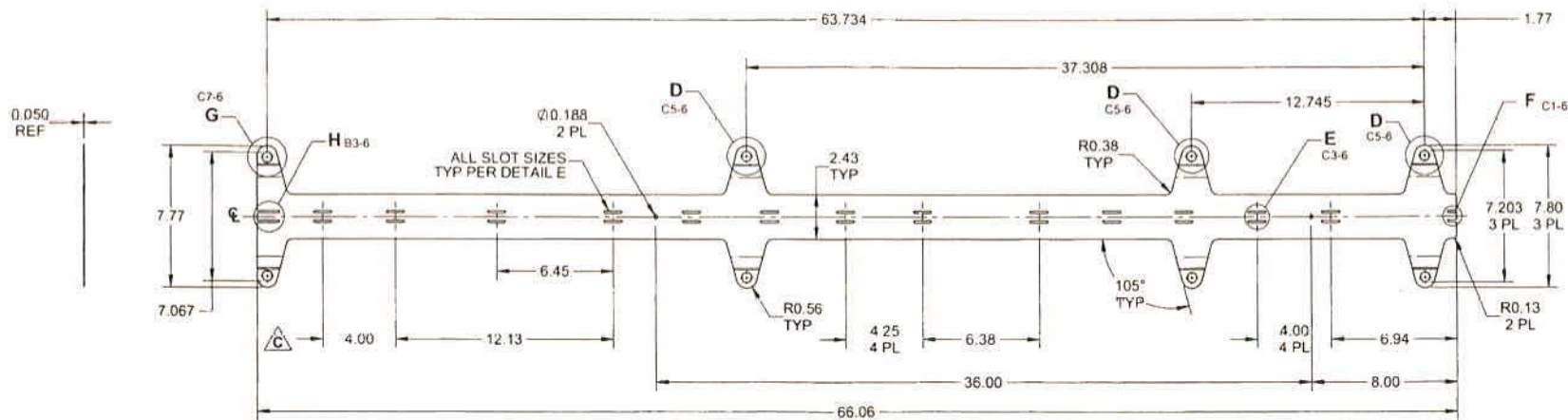
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2013-03-21

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CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR	JS	D4406	SHEET 3 OF 6
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104954



D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

RELEASED
2013-03-21
WJ

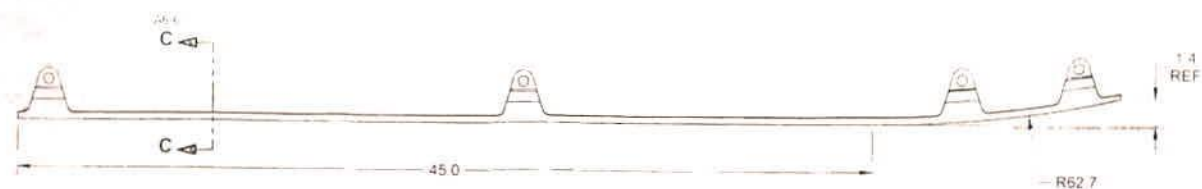
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

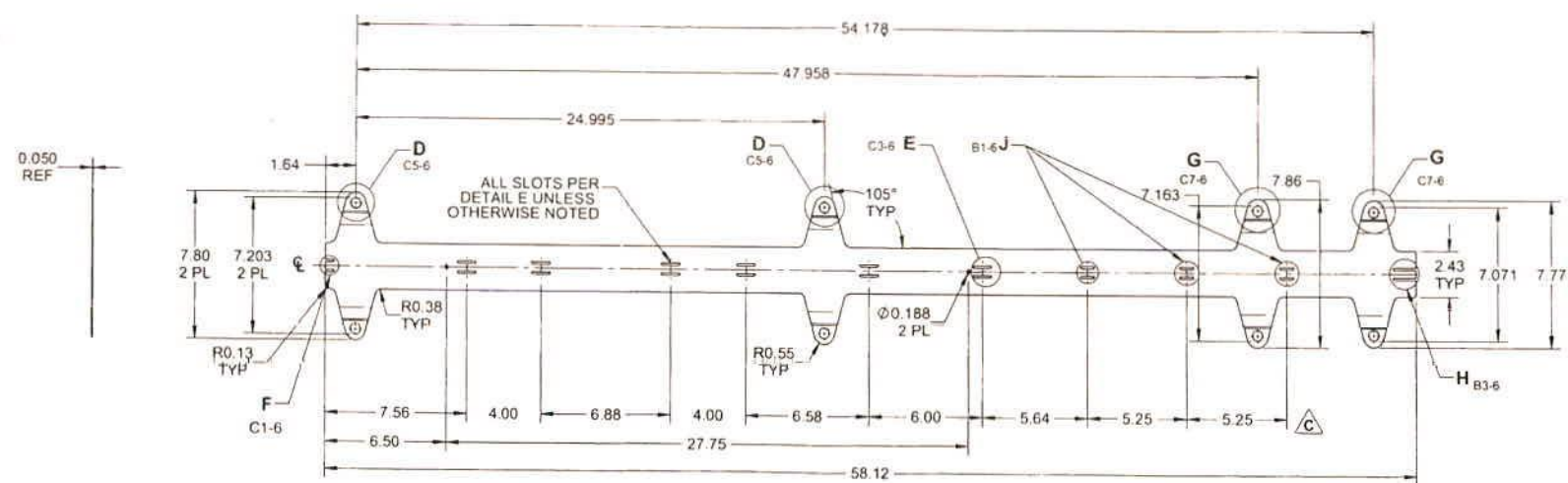
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

104934



D4406-3 PLATE
(MAKE FROM D4406-3F)



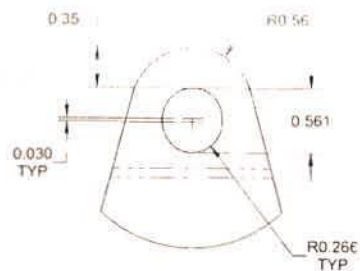
D4406-3F FLAT PATTERN

RELEASED
2013-03-21

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.5 lbs

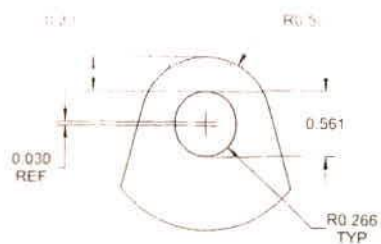
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DRAWN	AJS		
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MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 5 OF 6
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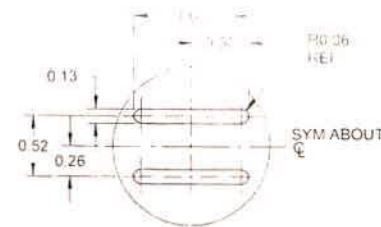
DETAIL G
SLOT DETAIL TYP
SCALE 6X

C2-4
C2-5
C3-5



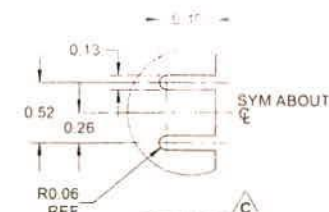
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C2-4
C3-4
C5-4
C5-5
C6-5



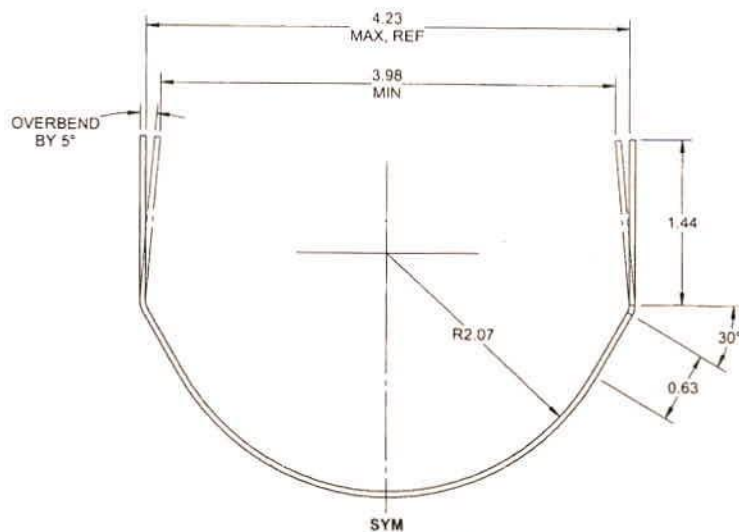
DETAIL E
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SCALE 6X

C2-4
C4-5



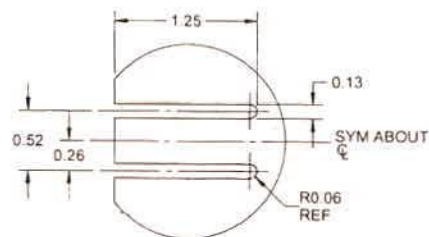
DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
97-5



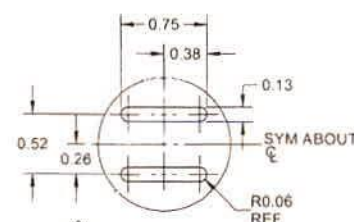
DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D6-5



DETAIL H
SLOT DETAIL TYP
SCALE 6X

C7-4
B1-5



DETAIL J
SLOT DETAIL TYP
SCALE 6X

C4-5

RELEASED
2013-03-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4406	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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